

20-8341



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3065-1

Job Sheet 205609



Part No: D3065-1

Job Qty: -60-pcs

Part Name: Step Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/20

Job Tracking No:

Due Date: 2/14/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	60 pcs		2/14/20	0.17	2.12	Waterjet - Flow		TF Mech, S. 2020
120	QC 8	60 pcs		2/14/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - 2 - B4B	60 pcs		2/14/20	0.00	0.75	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		

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					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	15 20-03-89
					Small Fab - Various 1 - B4B	
140	Small Fab - Brake NC - B4B	60 pcs	2/14/20	0.25 0.75	Small Fab - Brake - 1 - B4B	DAE 30 9-89
					Small Fab - Brake - 2 - B4B	MAR 10 2020
					Small Fab - Brake - 3 - B4B	
150	QC 5	60 pcs	2/14/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAE 58 9-89
					QC 5 - 68	MAR 11 2020
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Handfinish - 1-1 Chemical-B4B	60 pcs	2/14/20	0.00 1.50	Handfinish - 1 - 1 - B4B	BE 1320-03-19
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
161	QC 7	60 pcs	2/14/20	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	

				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	20-05-12
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
180	Packaging 3-1 - Stock - B4B	60	2/14/20	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B

DAS
94
989

DAS

84

9-89

GADFF

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	60 pcs	2/14/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

MAR 19 2020

Part Op 100 - 1- Cut as per Dwg D3065 2- DEBURR
 Descriptions: 120 - (QC8- Inspect parts - second check
 130 - FORM FLANGE AS PER DWG USING DT8174
 140 - BEND AS PER DWG
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)
 161 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Identify as per dwg & Stock Location: LOCATION : GA
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	7.4280 sf (.1238 ea)	100-Waterjet - Flow - 1	S242857

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.040	7	256	0

Part Specifications

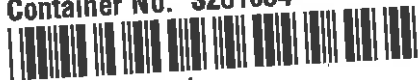
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.250inches ± 0.010	0.260 0.240	0.251	
2	Step Spacer	2.093inches ± 0.010	2.103 2.083	2.095	
3	Step Spacer	3.936inches ± 0.010	3.946 3.926	3.936	
4	Step Spacer	4.186inches ± 0.010	4.196 4.176	4.190	
5	Step Spacer	0.587inches ± 0.010	0.597 0.577	0.587	
6	Step Spacer	0.128inches + 0.005 - 0.001	0.133 0.127	0.130	
7	Step Spacer	0.125inches ± 0.010	0.135 0.115	0.125	
8	Step Spacer	3.465inches ± 0.010	3.475 3.455	3.465	
9	Step Spacer	1.250inches + 0.012 - 0.001	1.262 1.249	1.250	
10	Step Spacer	0.368inches ± 0.010	0.378 0.358	0.368	
11	Step Spacer	0.871inches ± 0.005	0.876 0.866	0.871	
12	Step Spacer	0.040inches ± 0.010	0.050 0.030	0.043	

DAS
64

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Container No: S261084



Part: D3065-1

Job No: 205609

Serial No/Batch: S261084

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
TEL.: 1 813 632-5208
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/05/20

Entered:

Date: AUG 24 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8341

Route update only ☐

Job: 205609 Part No. D3065-1		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date: MAR 11 2020		Sequence #: 130		QTY Affected: 1		MRB (QSI042) DAS 9 3-89 20.8.6																													
Description Work Order Deviation				Disposition																															
when forming inside put wrong on the J's				Scrap + destroy No replace																															
				Completed By DAS 58 9-89 MAR 11 2020																															
				Lead hand / Supervisor DAS 30 9-89 MAR 11 2020																															
				QC / QA Coordinator DAS 9 9-89 20.8.6																															
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☒ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☒ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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